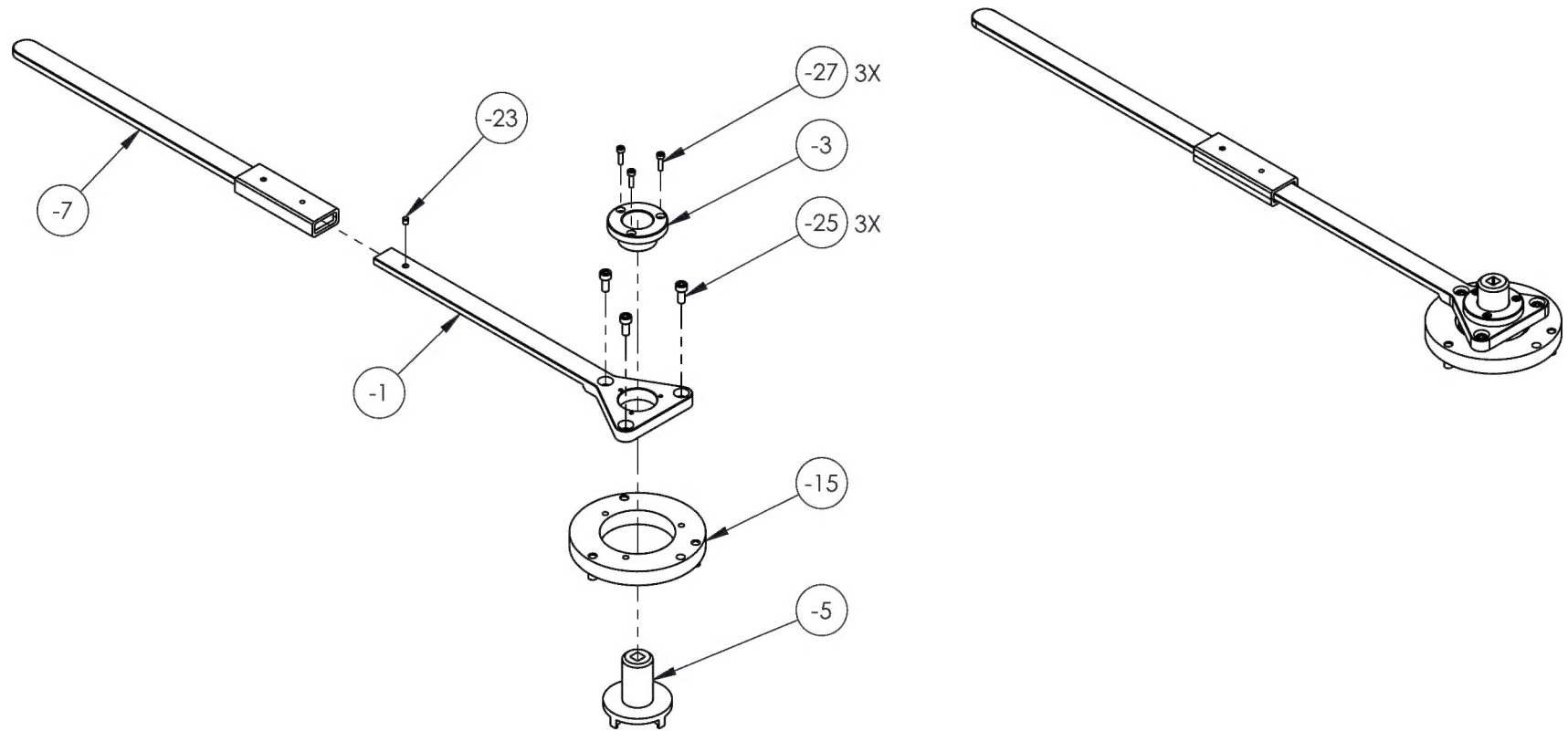


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/9/2016	DPD	JAG



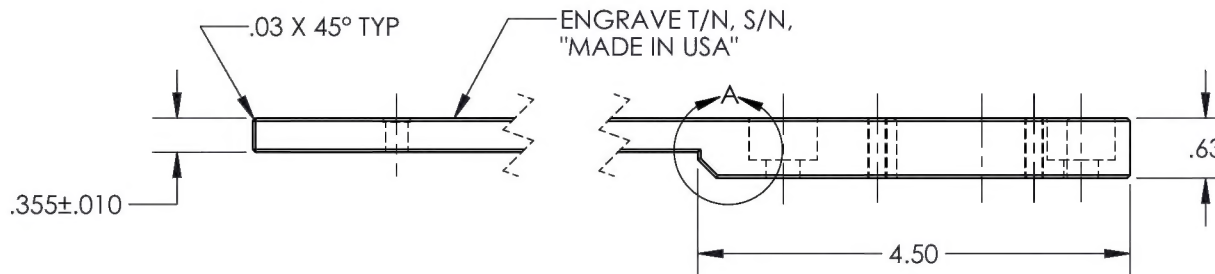
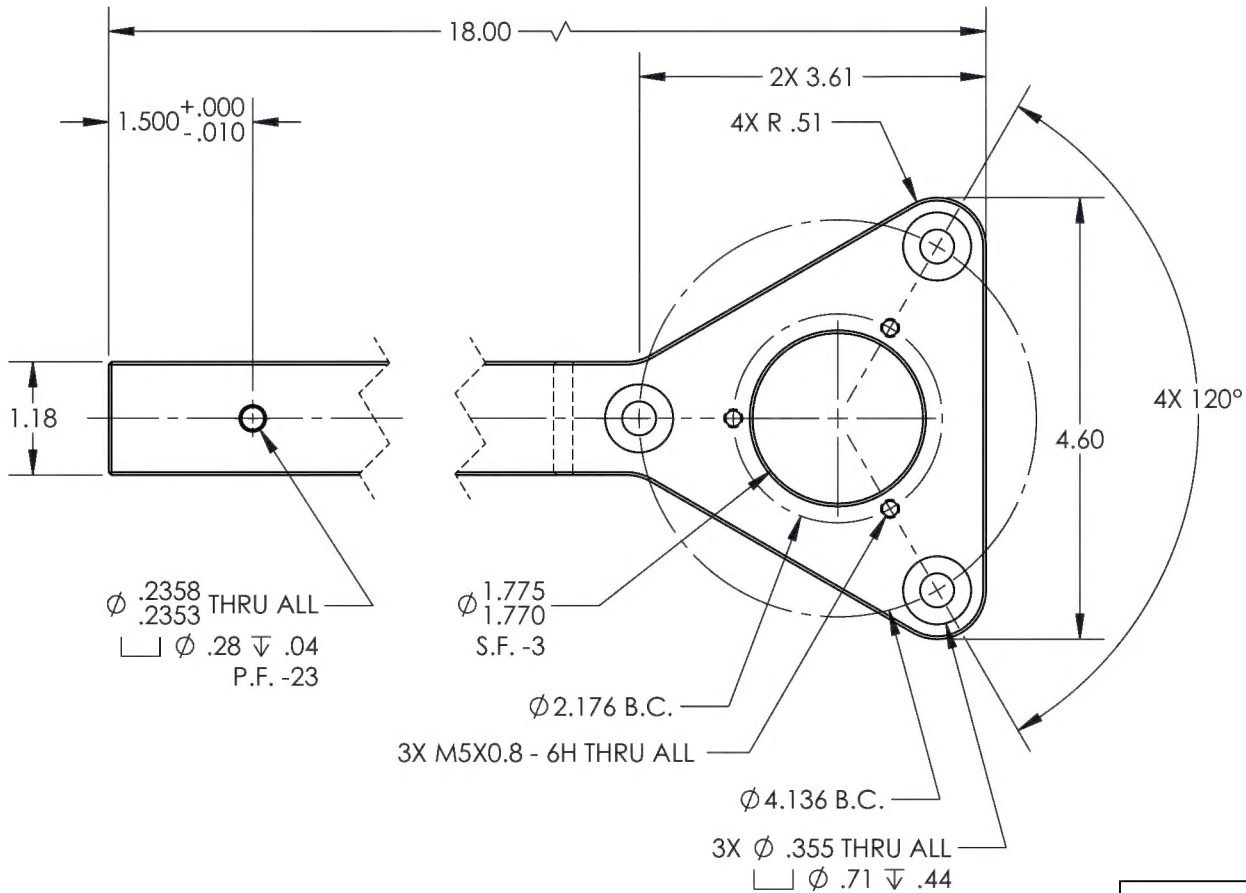
ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				-1	1	HANDLE	6061		2
				-3	1	BUSHING	6061		3
				-5	1	SOCKET	4140/4142		4
		X		-7	1	HANDLE EXTENSION ASSEMBLY			5
		1		-9		HANDLE EXTENSION	6061		6
	X	1		-11		EXTENSION BLOCK WELDMENT			7
	2			-13		HANDLE EXTENSION BLOCK	1018/1020 CR		8
X				-15	1	LARGE RING ASSEMBLY			9
1				-17		LARGE RING	6061		10
		1	B/O	-19		DOWEL PIN	STEEL	Ø1/4 X 3/4 (MCMaster-CARR #98381A540)	5
3			B/O	-21		DOWEL PIN	STEEL	M10 X 32mm (MCMaster-CARR #91595A650)	9
			B/O	-23	1	PLUNGER	S.S.	Ø.236 BODY X .24 BODY (MCMaster-CARR #84895A73)	1
			B/O	-25	3	SOCKET HEAD CAP SCREW	S.S.	M8 X 1.25mm X 18mm (MCMaster-CARR #91292A080)	1
			B/O	-27	3	SOCKET HEAD CAP SCREW	S.S.	M5 X 0.8mm X 18mm (MCMaster-CARR #91292A127)	1
ASSY -15	ASSY -11	ASSY -7							

NOTES:
REF. AIRBUS T/N: M632V3007128.
PART OF KIT RBEM632V3007102.

		TITLE	
		NUT KEY	
DWG NO.		RBEM632V3007128	
REV		1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		DUERFELDT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:8	
DATE		3/15/2016	
SHEET		1 OF 10	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

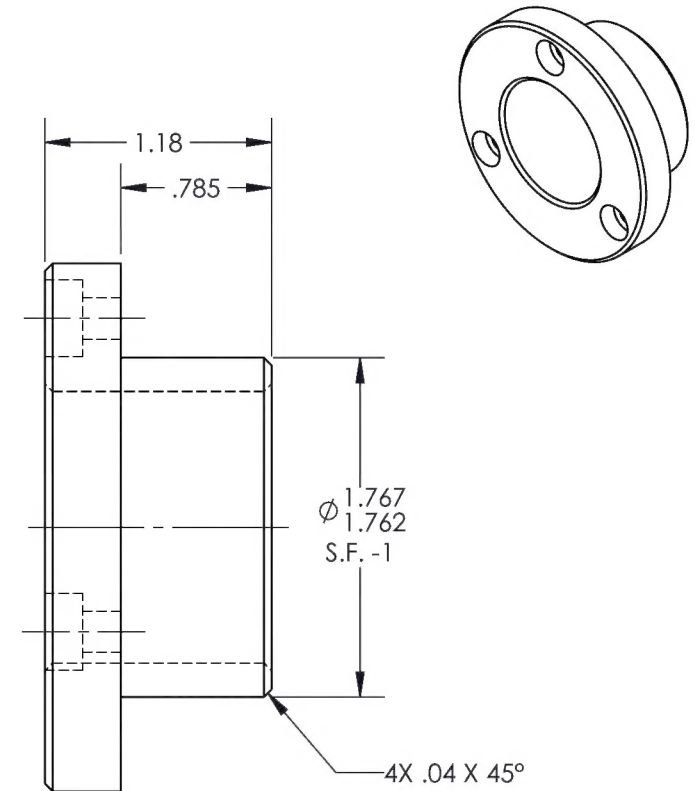
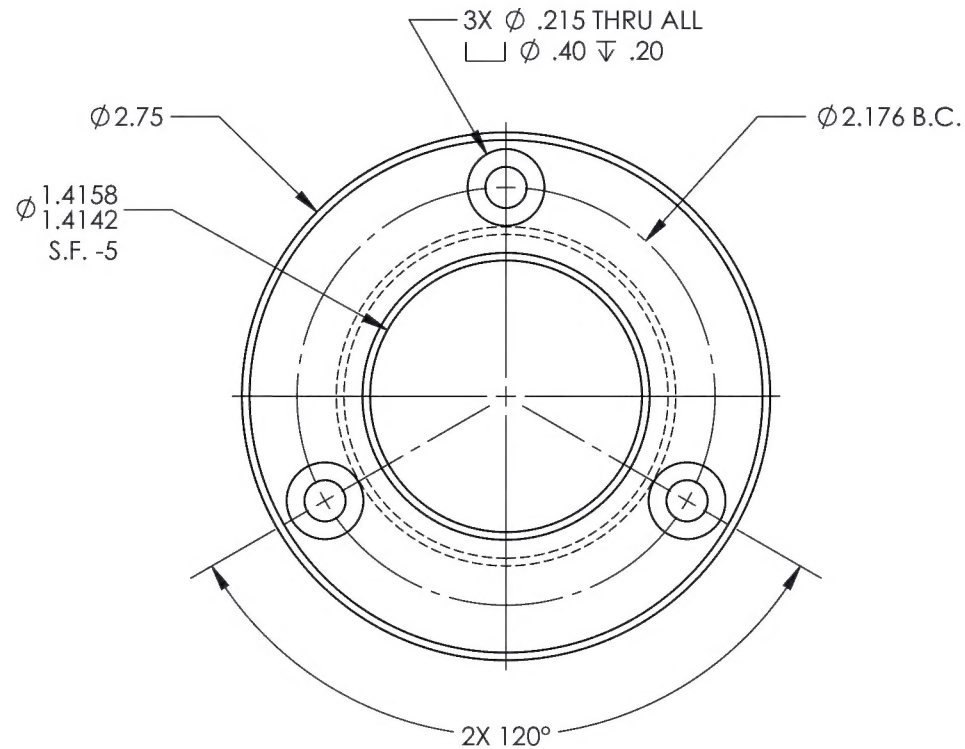


(-1)
HANDLE

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-1	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± .5°
SPEC MIL-A-8625, TYPE II, CLASS I	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/15/2016
SHEET 2 OF 10	

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				APPROVED

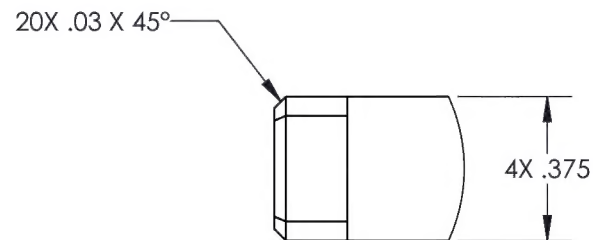
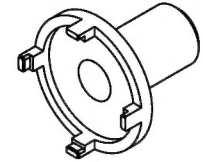
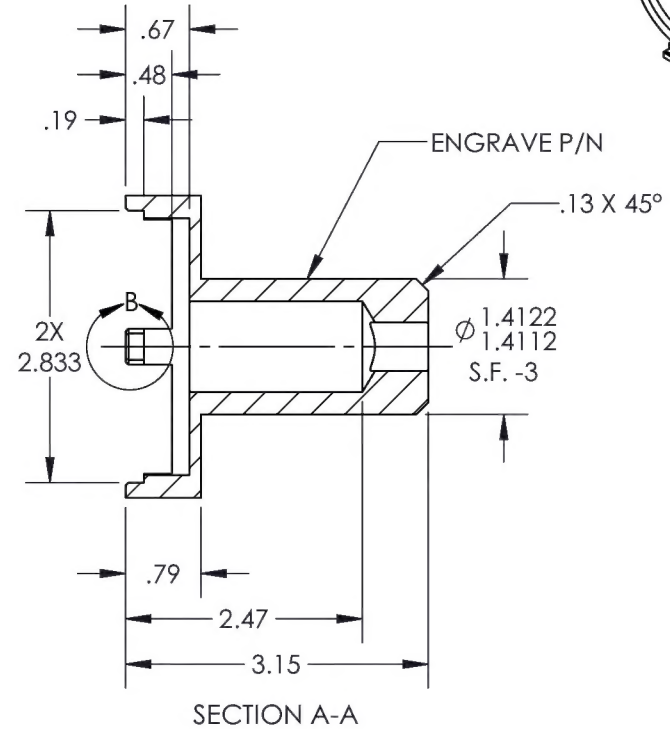
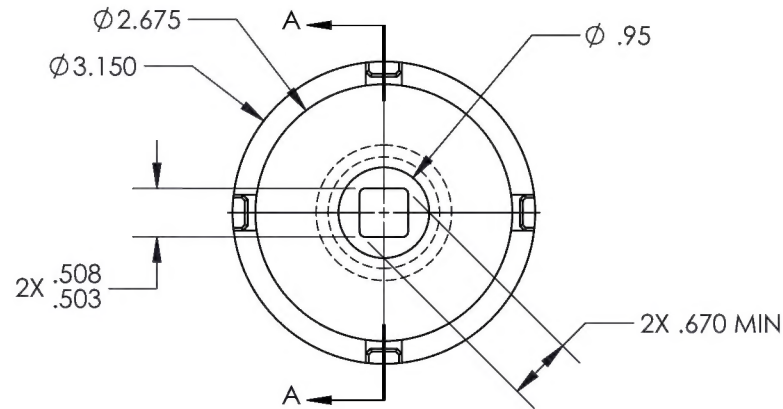


(-3)
 BUSHING

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-3	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC MIL-A-8625F, TYPE II, CLASS I	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: DUERFELDT	.X \pm .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/15/2016	USED ON MODEL
SHEET 3 OF 10	H175

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				APPROVED



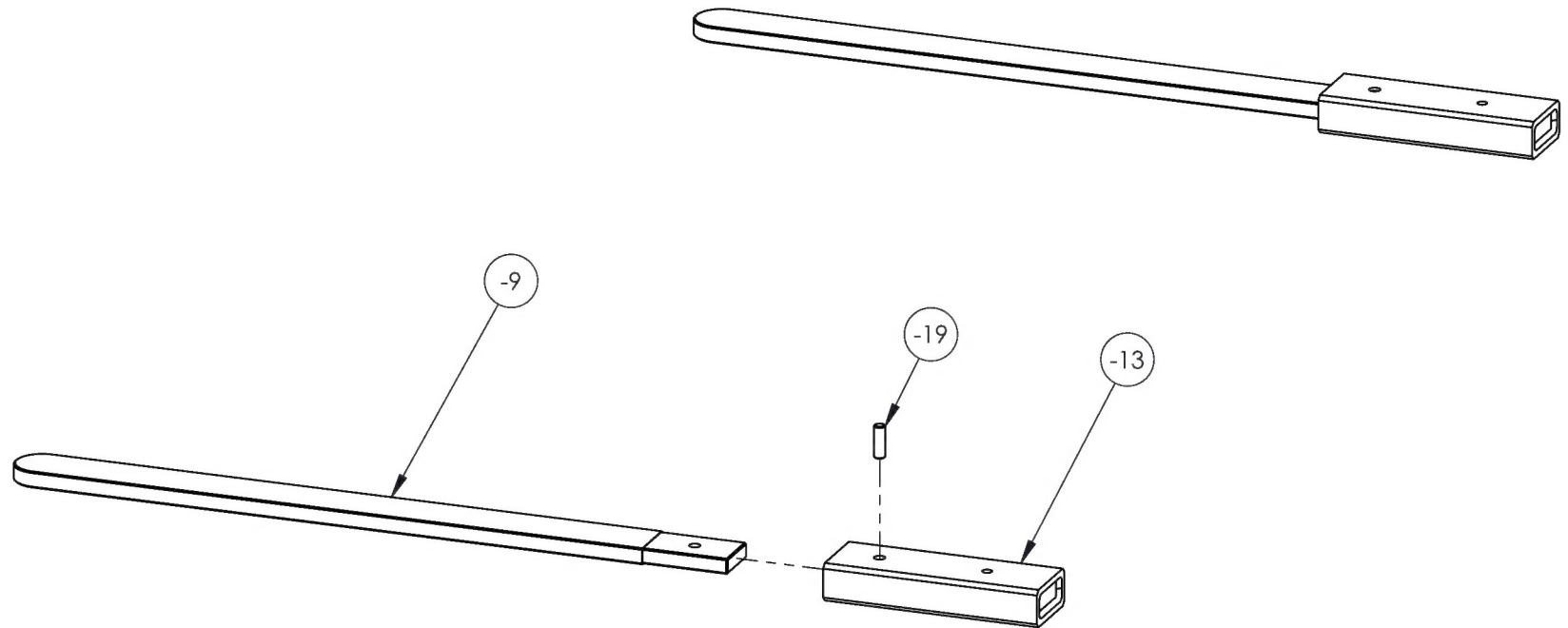
(-5)
SOCKET

DETAIL B
SCALE 2 : 1

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-5	REV 1
MAT'L 4140/4142 HEAT RC 36-40 TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm 5° .X \pm .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 3/15/2016
SHEET 4 OF 10	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



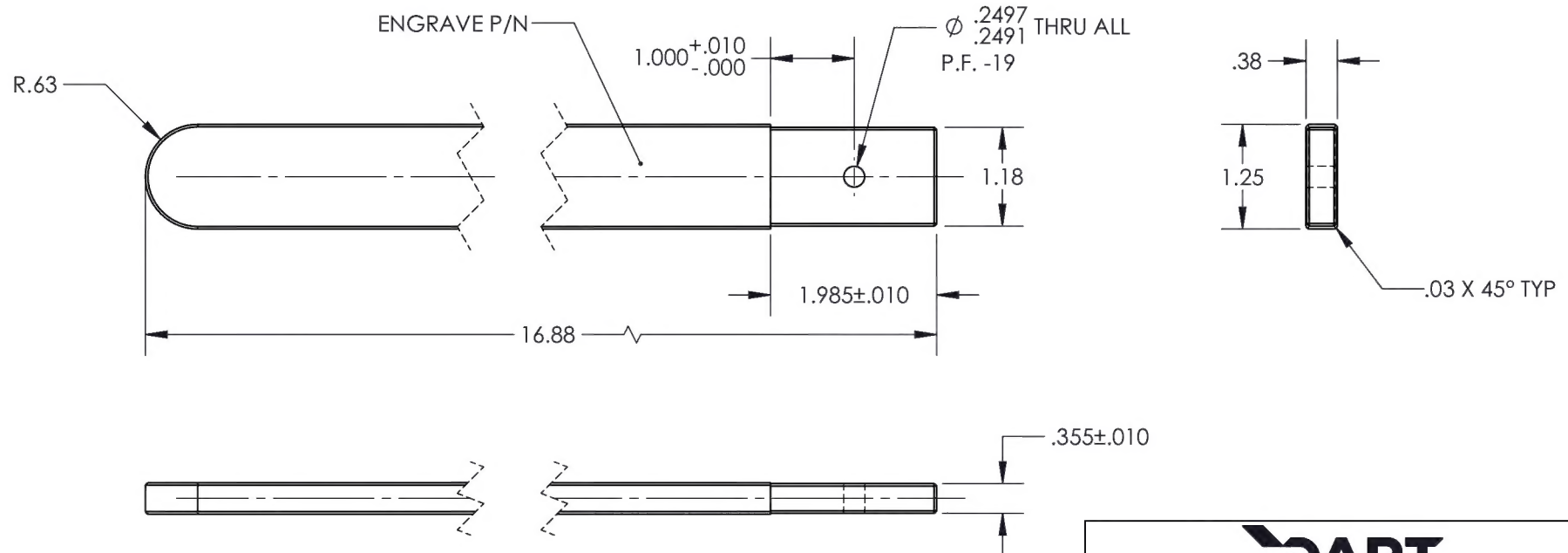
(-7)

HANDLE EXTENSION ASSEMBLY

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-7	REV 1
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 3/15/2016
SHEET 5 OF 10	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

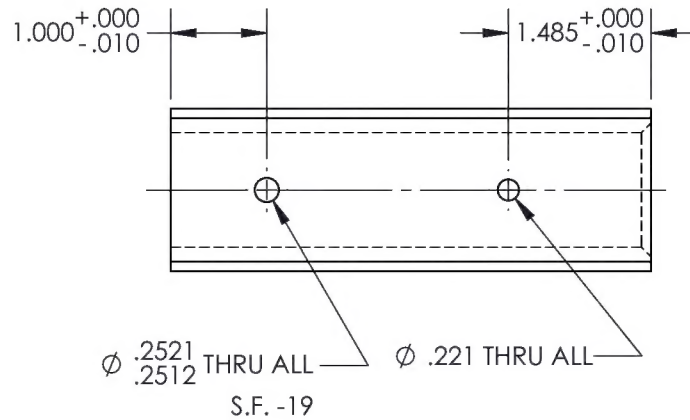
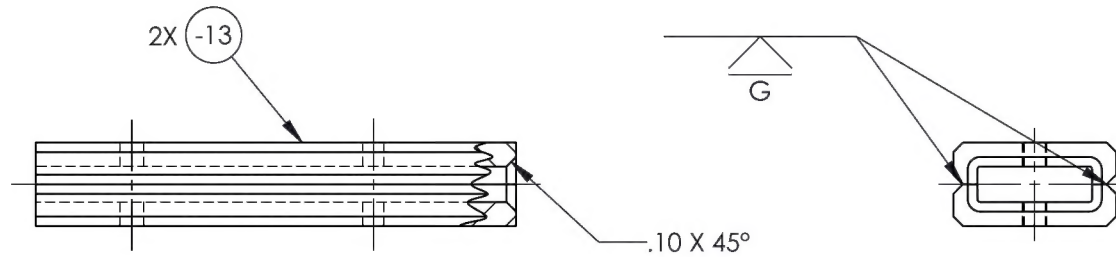
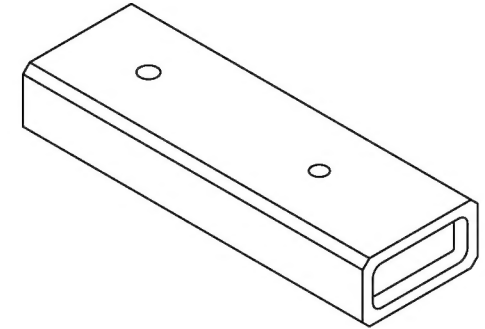


(-9)
HANDLE EXTENSION

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-9	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/15/2016
SHEET 6 OF 10	

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NOTE:
MACHINE AFTER WELD.

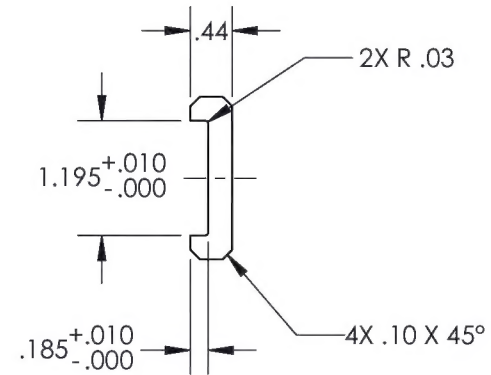
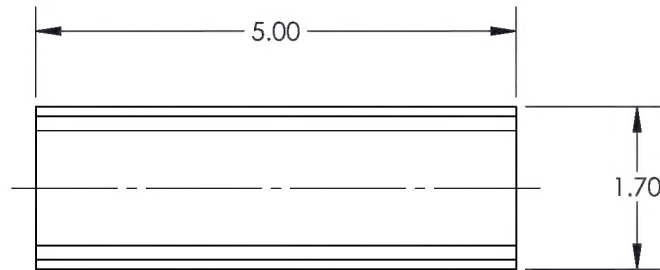
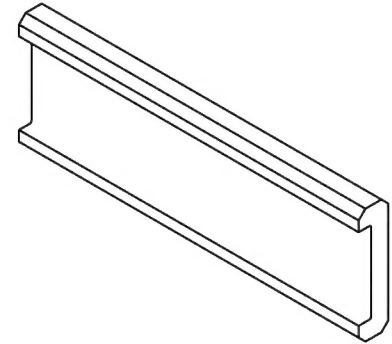
DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-11	REV 1
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
HEAT TREAT ZINC PLATE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: ANDERSON	USED ON MODEL
APPROVED: LINDSAY	H175
SCALE 1:2	DATE 3/15/2016
SHEET 7 OF 10	

(11)

EXTENSION BLOCK WELDMENT

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			INITIAL
			APPROVED



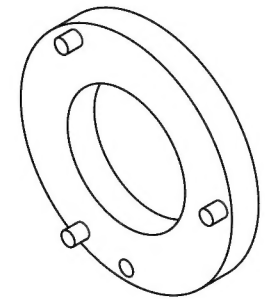
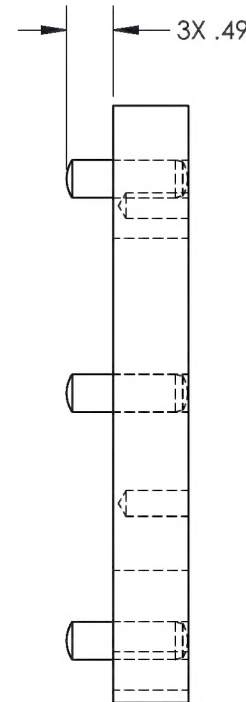
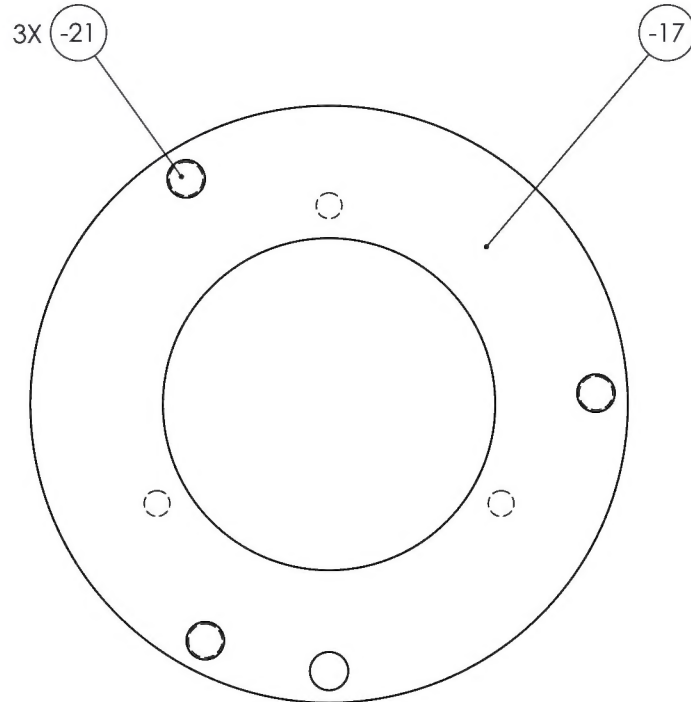
(-13)

HANDLE EXTENSION BLOCK

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-13	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -11	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/15/2016	USED ON MODEL
SHEET 8 OF 10	H175

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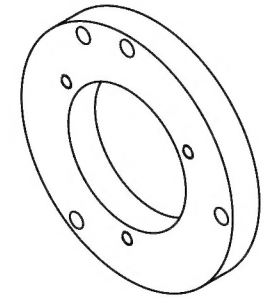
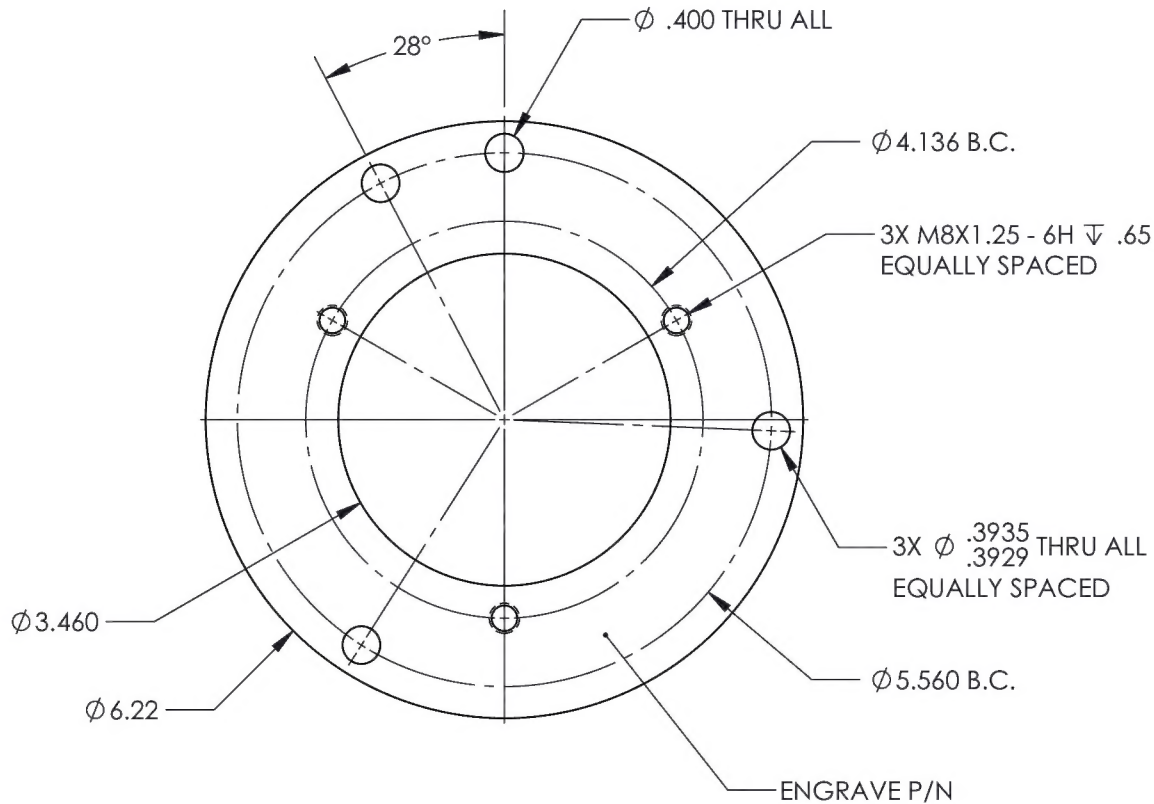
(15)

LARGE RING ASSEMBLY

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-15	REV 1
MAT'L REAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/15/2016
SHEET 9 OF 10	

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				APPROVED



(-17)
LARGE RING

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3007128-17	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH CLEAR ANODIZE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC MIL-A-8625, TYPE II, CLASS I	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: DUERFELDT	.X \pm .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:2	DATE 3/15/2016
SHEET 10 OF 10	